

**Work Order ID 59454**

Friday, June 04, 2010 2:40:42 PM

Page 1

Item ID: D500-572-021

Accept

Setup Start

Revision ID:

Stop

Item Name: Bearpaw

Start Date: 6/4/2010 Start Qty: 1.00

Required Date: 6/11/2010 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference: Return 2010 / RA110047

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date: 10/06/07

SPC (Y/N):

Date:

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2671

Rev B1

100

QC5- Inspect part completeness to step on W/O

0.00



QC

Quality Control

Memo

Original B42331 CHG006.

Kit needs fresh hardware, &amp; some cleaning up on the bearpaws to remove some minor scratches.

0.00

8/06/07

6

110

0.00



Thermoform

Thermoforming Machine

Memo

Wet sand &amp; polish the scuff marks on the bottom side of the bearpaws as necessary.

0.00

8/10/06/07  
x2

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Quality Control

Memo

0.00

8/06/07

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Reference: Return 2010 / RA110047

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool # Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

Pick Kit

0.00



Packaging

Packaging

S  
106663

Memo

New labels, &amp; paperwork required with the new batch # @ CHG006.

0.00

+ JG for BG 10/06/07

140

QC4- 100% Inspect kits for completeness

0.00



QC

Quality Control

Memo

0.00

S 106663

150

Identify as per dwg & Stock Location: 11A

0.00



Packaging

Packaging

Memo

0.00

Return

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Item ID: D500-572-021

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Setup Start



Revision ID:

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Item Name: Bearpaw

Start Date: 6/4/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 6/11/2010 Req'd Qty: 1.00



Customer:

Reference: Return 2010 / RA110047

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

QC21 - Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/06/08 *[Signature]*  
M10-6-08  
①

# Picklist Print

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Work Order ID: 59454

Parent Item: D500-572-021

Parent Item Name: Bearpaw

Comments: IPP Rev:C 04.02.17 Blank size changed KJ/JLM  
IPP Rev:D 07-01-02 Was K10005 JLM  
IPP Rev:E 08-10-14 Added Step 2 JLM Verified By:DD  
IPP Rev:F New Manufacturing Method 08-10-29 JLM Verified By:EC

Start Date: 6/4/2010

Required Date: 6/11/2010

Start Qty: 1.00

Required Qty: 1.00

AN4-15A- Purchased No 170 Each 363.0000 8 8  
Bolt  
M107737

Location	Loc Qty	Loc Code
ST358	363	
114239	3	
114292	60	
114615	100	
114784	200	

AN960JD416 7 NAS1149D0463J Purchased No 170 Each 0.0000 8 8  
Washer  
D2182B (A2182-050)  
Rubber Cushion  
M167939

Location	Loc Qty	Loc Code
ST402A	9.67	
30872	9.67	
ST410	312.9138	
52649	312.9138	

D2274- 7 Manufactured No 170 Each 509.0000 8 8  
Radius Block  
52649  
C144711

Location	Loc Qty	Loc Code
ST010	509	
56686	3	
57714	233	
57912	273	

57714

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 IPP Rev:E 08-10-14 Added Step 2 JLM Verified By:DD  
 IPP Rev:F New Manufacturing Method 08-10-29 JLM Verified By:EC

Start Date: 6/4/2010

Required Date: 6/11/2010

Start Qty: 1.00

Required Qty: 1.00

D2438 Manufactured No 170 Each 73.0000 4 1 4  
 Clamp

Location	Loc Qty	Loc Code
ST456	73	
55603	73	

D2529 Manufactured No 170 Each 622.0000 8 8  
 Washer

Location	Loc Qty	Loc Code
ST017	622	
56184	22	
58568	600	

MS21042L4 Purchased No 170 Each 4,043.000 8 18  
 Nut

Location	Loc Qty	Loc Code
ST139	2	
111827	2	
ST300	4041	
113422	68	
114523	965	
114718	1000	
114784	2000	
9063	8	

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Required Date: 6/11/2010

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Start Qty: 1.00

Required Qty: 1.00

IPP Rev:D 07-01-02 Was K10005 JLM

IPP Rev:E 08-10-14 Added Step 2 JLM Verified By:DD

IPP Rev:F New Manufacturing Method 08-10-29 JLM Verified By:EC

QS200-M44S

Purchased

No

100

Each

10.0000

2

1/2



Clamp

*Signature* 1/4/10 ①

Location

Loc Qty

Loc Code

ST450

10

113288

10

113288

8

## 32.3 WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D500-572-011 Bearpaw Installation	8.5 lb 3.86 kg	0.0 in 0.0 m	0.0 lb-kg 0.0 m-kg	130 in 3.30 m	1105 in-lb 12.74 m-kg
D500-572-021 Narrow Bearpaw Installation	7.5 lb 3.41 kg	0.0 in 0.0 m	0.0 lb-kg 0.0 m-kg	130 in 3.30 m	975 in-lb 11.25 m-kg
D500-572-013 Bearpaw Installation	11.4 lb 5.17 kg	0.0 in 0.0 m	0.0 lb-kg 0.0 m-kg	128 in 3.25 m	1459 in-lb 16.80 m-kg
D600-572-015 Bearpaw Installation	11.4 lb 5.17 kg	0.0 in 0.0 m	0.0 lb-kg 0.0 m-kg	122 in 3.10 m	1391 in-lb 16.03 m-kg

## 32.4 PARTS LIST

Qty D500 -572 -011	Qty D500 -572 -021	Qty D500 -572 -013	Qty D600 -572 -015	Part Number	Description
X				D500-572-011	BEARPAW INSTALLATION
	X			D500-572-021	NARROW BEARPAW INSTALLATION
		X		D500-572-013	BEARPAW INSTALLATION
			X	D600-572-015	BEARPAW INSTALLATION
2				D2435	BEARPAW
	2			D2671	BEARPAW
		2		D2995	BEARPAW
			2	D2996	BEARPAW
4	4	4		D2182B050	RUBBER CUSHION
			4	D2182B060	RUBBER CUSHION
8	8	8	8	D2274	RADIUS BLOCK
4	4	4		D2438	CLAMP
			4	D2519	CLAMP
8	8	8	8	D2529	WASHER
		8	8	AN4-13A	BOLT
8	8			AN4-15A	BOLT
8	8	8	8	AN960JD416	WASHER
8	8	8	8	MS21042L4	NUT (OR MS21042-4)
2	2			QS200M44S	CLAMP
			4	QS100M24S	CLAMP

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32-00-00

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries